Work Orde				*107	7129*							Page 1	
Revision ID:	D4021-5 Blanking Plate			Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1* S2*	
Start Date: Required Date: Reference:	10/02/13 10/02/13	Start Qty: 4.00 Req'd Qty: 4.00	*A* *A*	x8*	Cust Item I Customer:	D:							
Approvals:	Process Pla	ın:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II	0	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp	 :
Draw Nbr	Rev	ision Nbr	-										- :
D4021	В												
100				0.00									Politica -
100 Waterjet FLOW CNC Waterje		Memo Cut as per d Prog Rev:	<u>3</u>	0.00				-8-		0_		13:11:	.07
***		Dwg Rev:	 -										
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00									
110 QC Quality Control		Memo		0.00				8	<u>`</u> —	O		Ac 13.1	1.07

NCR: Y	es/	/ No				WORK ORDER NON-O	100	NFORM	AANCE / UPD	ATE	·		
		ļ									QA Closed:	Date:	
Work Orde	sė.	!				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde		į	•			Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap	1 1	i .	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_				·	Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR N	No	<u> </u>				Work Order Update]	1	Large Fab	Composite		Supplier	
Root		· · ·			Descri	ption of work order update		Initial	Actio	on	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data	Ц	Ï											
Equip/Tooling	Ц	1											
Operator	Ц												
Material	Ш												
Setup	Ш	!	1										
Other	Ш												
Process	Ш												
Supplier	Ш	1											
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Unapproved				<u> </u>			<u> </u>						
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Landi						General		7			1	_	7
	\vdash	Bending				Bend	$oxed{oxed}$	Grain			Ovalized		Pressure/Forced
	-	Centre No	ot Conce	ntric to (D/S	BOM/Route	\vdash	Hardwa	-		Over/Under		Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	<u>_</u>	4 `	ion Incomplete		Part Incorre	ct	Weld
	-	Crushed/	Crimped		<u> </u>	Burrs	L	-1	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Ш	Cuffs				Contamination	\perp	Mainte		ļ	Part Moved		
	Ш	Heat Trea	at		L	Countersink		Mislabe	led		Positioned V		-
	Ш	Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
		Ripples ir	n Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-23-1	3 11:09:20 A	4M											
Item ID: Revision ID:	D4021-5			Accept	*1	1900	040	100)* s	etup Star	ıv.	S1*	
Item Name:	Blanking Plat	te								Stop	' *N:	S2*	
Start Date: Required Date:	10/02/13 : 10/02/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*			Cust Item II Customer:	D:						
Reference:			•							_			
Approvals:	Process Pl	an:	Date:	Tooling:		Da	ite:		F	tun Star Stoj	"1/1	R1*	
	QC:		_ Date:	SPC (Y/N):		Da	ıte:			Stop	' *NI	R2*	
Sequence ID/ Work Center I	D	Operation Description QC8- Inspect parts - sec	ond check	Set Up/ Run Hours 0.00 DA 2	s 7	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
120 QC Quality Control		Memo		0.00	07							··	_
*130		White Gloss(Ref: 4.3.5.2)	- 1:00	0.00					R	h	13-11-7	,	DAS 34
Powdercoat Powder Coating		Memo OU	SINCT 1/00° 11:61 1/30.	0.00						-			-9-89
*135		QC3- Inspect Part Finish	h	0.00 DA	7				8				
QC Quality Control		Memo		0.00 13 99	07								

		į	
NCR:	Yes /	No.	WORK ORDER NON-CONFORMANCE / UPDATE

Finish

Folio

NCR: Y	es / No				WORK ORDER NON-	CON	IFORN	MANCE / UP	DATE			
	·									QA Closed:	Dat	te:
Work Orde	r: i				DISPOSITION				AGAINST D	EPARTMENT	PROCESS	
Part N	0				Rework Scrap Use-as-is		Machining Small Fal		Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR N	0.				Work Order Update			Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	lr	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	n QC Inspector
Doc/Data	:											
quip/Tooling												ĺ
Operator												
Material	\dashv						3					
etup												
Other		-								Į į		
Process						ĺ				1		
Supplier	- :									ł		
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}	Bending				Bend BONA/Danks	\vdash	Grain		ļ	Ovalized	A -1	Pressure/Forced
-	Centre No	ot Conce	ntric to	^{3/5} -	BOM/Route	-	Hardwa		-	Over/Under Part Incorred		Temperature/Cure Weld
}	Cracks	·C		-	Broken/Damaged	-	•	ion Incomplete	Lindoor			Wrong Stock Pulled
}	Crushed/	Crimpea		<u> </u>	Burrs		Mainte	ions Incomplete/	Unclear	Part Lost/Mi Part Moved	22IIIB	wrong stock Pulled
}	Cuffs				Contamination Countersink	\vdash	Mislabe		 -	Positioned V	Vrong	
-	Heat Trea		Tuba	-	┥	\vdash			 	Power Loss/	Ŭ 1	Other
-	Inspectio	·-	rube	-	Cut Too Short Drill Holes		Misread Offset	1	L	rower Loss/	ourge	Touler
}	Ripples in		Evenio	<u>,</u> ⊢				Calibration				
	Torque V	vaves in i	ことにはらり	1	Drawing	1 1	Out of (Janui alion				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Work Order ID 107129

107129

Page 3

September-23-13 11:09:26 AM *N900040100* Item ID: D4021-5 Accept Setup Start **Revision ID:** Blanking Plate Item Name: Start Qty: 4.00 Start Date: 10/02/13 **Cust Item ID:** Req'd Qty: 4.00 Required Date: 10/02/13 **Customer:** Reference: Run Process Plan: Tooling: Approvals: Date: Date: Stop Date: _____ SPC (Y/N): QC: Date: Tool # Plan Sequence ID/ **Operation** Set Up/ Tool ID Accept Reject Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours** Identify as per dwg & Stock Location: 57083 140 0.00 *140* 0.00 Packaging Memo Packaging 150 QC21- Final Inspection - Work Order Release 0.00 W/3-01-11 MI 13-11-11 *150* QC 0.00 Memo Quality Control

	•								DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-C	ONFOR	MANCE / UI		QA Closed:	Date:	
NA/ and a Constant	-				DISPOSITION			AGAINST DE			
Work Order Part No	o				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Crosstub Machining Small Fa Thermoforming Finishir Large Fab Composit		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root	'			Descri	ption of work order update	Initial	Α	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Des	scription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling	1					Ì					
Operator	T :										
Material	7 :										
Setup	☐	9							<u></u>		
Other	7			1							
Process		ĺ									
Supplier	1		•								
Training							ľ				
Unapproved			<u> </u>						<u> </u>		
					F	AULT CAT	EGORY				
Landin	g Gear				General			_	3		,
L	Bending				Bend	Grain			Ovalized		Pressure/Forced
L	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardw	/are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	instru	ctions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Main	tenance		Part Moved		
[Heat Trea	at			Countersink	Mislat	peled		Positioned \	V rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing Finish

Folio

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Picklist Print

September-23-13 11:09:25 AM

Work Order ID:

107129

Parent Item:

D4021-5

Parent Item Name:

Blanking Plate

Start Date: 10/02/13

Required Date: 10/02/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC

IPP Rev:B as per dwg REV.A DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	537.0600	0.0622	0.2618947	Au	13.	11 .0
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT020		537.0599998							
				1231	136	140.2							
				M12	6159	35			·		c		
				M12	6915	361.86			120	5915.	\longrightarrow	. (~	*

NCR: Y	es / No				WORK ORDER NON-C	LONF	·OKI	MAINCE / UP		QA Closed:	Date	:
Work Orde					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					Rework]		Skid-tube	Crosstube Small Fab	Dro	Water Jet d. Eng. Coor.	Engineering Quality
Part N	0				Scrap	┨		Machining				⊸ l '┝━━'
NCR N	0				Use-as-is Work Order Update] '		noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Init	tial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	f Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		ł										
Operator		j	}									
Material											:	
Setup	_		į			1						
Other			ļ			1						
Process								: :				İ
Supplier	_					Ì						
Training												
Unapproved		1		<u> </u>	:						<u> </u>	
					·	AULT	CATE	GORY				
Landir r	ng Gear			r-	General					1	Г	¬_ <i>,</i>
1	Bending	_		_ ,_	Bend	-	irain			Ovalized	., ⊢	Pressure/Forced
1	⊣	ot Conce	ntric to	O/S	BOM/Route	\vdash	ardwa			Over/Under	}	Temperature/Cure
-	Cracks			 	Broken/Damaged	—		on Incomplete	,,	Part Incorre	}	Weld
		/Crimped		<u> </u>	Burrs			ions Incomplete/	Unclear	Part Lost/Mi	· -	Wrong Stock Pulled
}	Cuffs			<u> </u>	Contamination	1		nance	ļ	Part Moved		
	Heat Tre		. T. da a		Countersink	$\boldsymbol{\vdash}$	/lislabe		<u> </u>	Positioned V Power Loss/		Other
		on Strip ir	ıube	<u> </u>	Cut Too Short Drill Holes	-	⁄lisreac Offset	1	L	Jeower Loss/	Surge	Tottler
	Ripples i		F	_		\vdash		Calibration				
		Waves in		^{'n} -	Drawing Finish	\vdash		Calibration Sequence				
	i ilurning	Seauence		1	IFINISN	1 10	JULE OT S	sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	18429
Description: Blanking Plate	Part Number:	D4021-5
Inspection Dwg: D4021 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	x	First Artic	:le	_ Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	.194			V	JKM-01
3.50	+/-0.030	3,50	/		\mathcal{L}	
2.56	+/-0.030	2.56	/		V	
0.81	+/-0.030	,81	/		V	
0.060	+/-0.010	1059			ν	
		′				

Measured by:	Audited by: 9-89	Preliminary Approval:	
Date: 13.11.07	Date: 3 1	7 Date:	

Rev	Date	Change	Revised by A	Approved
Α	10.04.20	New Issue	KJQK//	M
				

